

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003998**Date Inspected:** 27-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Larry Viars was present to observe the Production Monitoring Test (PMT) and perform Ultrasonic Testing (UT) for Orthotropic Box Girder (OBG) components, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Sub Assembly Shop Bay 1:

Gantry 1 / PMT 1

The Caltrans QA Inspector monitored the OBG Production Monitoring Test (PMT) for Deck Panels DP497-001. The Caltrans QA inspector recorded amperage, voltage and travel speed of the Gas metal Arc Welding (GMAW) root pass and the Submerged Arc Welding (SAW) cover pass. A Visual inspection of the root pass and cover pass was performed by ZPMC, American Bridge Flour (ABF) and the Caltrans QA. The Caltrans QA observed ZPMC QC Ma Jilong perform Ultrasonic testing of the Partial Joint Penetration weld for depth of penetration. Mr. Ma found the depth of penetration of the PMT welds to be in compliance with contract documents. The Caltrans QA inspector designated locations for Macroetch samples (10 locations). Macroetch samples were evaluated with a 7x optical comparator and accepted by ZPMC QC, ABF QC and The Caltrans QA Inspector.

DP497-001: Tack weld grinding has been completed. ZPMC has not performed MT of tack excavations.

Heavy Machinery Tower Bay 2:

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The Caltrans QA performed UT Verification testing of ZPMC Quality Control (QC) tested and accepted Tower Skin E longitudinal stiffener welds, ESD1-SA216 G/K 3, 6, 25 and 28. No relevant indications were noted during testing.

No other activities observed.

Summary of Conversations:

Only general conversations between Caltrans QA and QC occurred this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann 150 0219 9593, who represents the Office of Structural Materials for your project.

Inspected By:	Viars,Larry	Quality Assurance Inspector
Reviewed By:	Wright,Mark	QA Reviewer
